

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012511**Date Inspected:** 09-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 6 WEST

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the CAX74L Designation are as follows.

SEG027H-065~068, 089~091

ULTRASONIC INSPECTION

OBG SEGMENT 6WEST

PUNCH LIST ITEM

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Q.A Inspector performed Ultrasonic Inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the OBG segment 6West Designation are as follows.

OBW6F-009	Punch list item# 441
OBW6F-007	Punch list item# 471
SSD025-PP45-171	Punch list item# 423

ULTRASONIC INSPECTION

OBG SEGMENT 6WEST

This Q.A Inspector performed Ultrasonic Inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the OBG segment 6West Designation are as follows.

OBW6F-001,002,004~007, 009~018

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7BW-7CW

This Quality Assurance (QA) Inspector observed ZPMC personnel performing carbon air arc gouging on the side panel splice weld between OBG segments 7BW and 7CW (cross beam side).

This Quality Assurance (QA) Inspector observed ZPMC personnel performing carbon air arc gouging for the removing of temporary attachment (Dog plate) at the side panel splice weld between OBG segments 7BW and 7CW (counter weight side).

OBG SEGMENT 6AW

This Quality Assurance (QA) Inspector observed ZPMC Inspector performing Magnetic Particle Inspection on the weld between deck panel "I" rib and edge panel in FL -003 location near the PP38.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer